Work Order ID 58071 Page 1 April 22, 2010 2:22:36 PM D4048-9 Item ID: Accept Setup Start **Revision ID:** Stop Bushing Item Name: **Start Qty: 50.00 Start Date:** 4/22/10 **Cust Item ID: Req'd Qty:** 50.00 Required Date: 4/30/10 **Customer:** Reference: Run Start Date: 10-11-22 Pooling: **Process Plan:** Date: _____ Approvals: Stop QC: SPC (Y/N): Date: Date: Reject Sequence ID/ Operation Set Up/ Draw Plan Reject Draw Accept Insp. Work Center ID Description Number Rev. Code Qty Qty Number Stamp **Run Hours Draw Nbr Revision Nbr** D4048 Α 0.00 0.00 Hardinge Memo IL 1001/28 TURN AS PER DWG AND FOLIO FA891 Hardinge CNC Lathe Small DWG REV: FOLIO REV: **DEBURR** 110 QC2- Inspect parts off machine FAI/FAIB 0.00 JL 10/04/28

0.00

Memo

Quality Control

Dart Aerospac	e l	_td
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W/O:		1	V	VORK ORDER CHANGI	ES							
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Resolution:			_ Disposit	tion:	_ QA:	N/C	Clos	osed: Date:				
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April 22, 2010 2:22:36 PM

Required Date: 4/30/10

Item ID:

D4048-9

Accept

Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Bushing

4/22/10

Start Qty: 50.00

Req'd Qty: 50.00



Cust Item ID:

Customer:

Draw

Reference:

Approvals:

Process Plan:

Date:

Tooling:

0.00

0.00

Date:

Draw

Plan

Run Start

Date: _____

SPC (Y/N):

Date: ____

Stop

Sequence ID/ **Work Center ID**

120

Quality Control

Operation **Description**

QC8- Inspect parts - second check

Memo

Memo

Set Up/ **Run Hours**

Number Rev.

Accept Code Qty

Reject Qty

Reject Insp. Number Stamp

130



Packaging

Identify as per dwg & Stock Location:

0.00

0.00

140



Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Dart Aerospac	e L	_td
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W/O:			٧	VORK ORDER CHANGE	ES					
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DATE	STEP	Description of NC	Description of NC Corrective Action				Verificatio	n Approval	Approval	
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		Section C			Chief Eng	QC Inspector
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Picklist Print

April 22, 2010 2:22:35 PM

Work Order ID: 58071

Parent Item:

D4048-9

Parent Item Name:

Bushing

Comments:

IPP REV:A NEW ISSUE 10-01-07 JLM VERIFIED BY:DD as per dwg revA DD 10.02.18 verified by:EC

IPP Rev:B

Start Date: 4/22/10

Required Date: 4/30/10

Start Qty: 50.00

Required Qty: 50.00

Component Item ID/

Item Name

Replacement Mfg/ Item ID

Purch Purchased Bin Primary Item Location No

Last Location Route Seq ID 100

Unit of Measure Hand

Qty on 22.2000

Remaining 1.9474

Qty Qty To Pick Issued Date Issued

Status

Page 1

M304R.500

304 SS roundbar .500

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT029

113006

22.2

22.2

2.0 JL 18/04/28

Dart Aerosp	ace Ltd	
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W/O:			W	ORK ORDER CHANG	iES					
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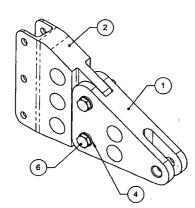
DART AEROSPACE LTD	Work Order: 5707	
Description: Dushing	Part Number: _164\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	
Inspection Dwg: ハリカン Rev: A	Page 1 of 1	

	FIRST ARTICLE INSPECTION CHECKLIST								
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-370	±.010	.375							
.050	± 010	.051							
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Measured by:	<u> </u>	Audited by:	S.B.		Prototyp	e Approval:	N/A		
Date: /	0/04/28	Date:	0/04/28	,]		Date:	N/A		
Rev Date	Change					Revised by	Approved		
Α	New Issue					KJ/JLM			

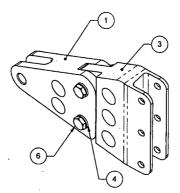
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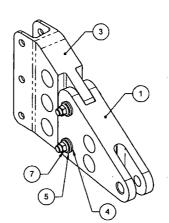
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D4048-041 MOUNTING LUG ASSY (SHOWN)





NOTES: 1) MATERIAL: N/A 2) FINISH: NONE 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: N/A 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4048-041/-042" USING FINE POINT PERMANENT INK MARKER 7) WEIGHT: D4048-041/-042: 1.16 lbs 8) TORQUE AN4 BOLTS TO 50-70 in-lbs (5.6-7.9 Nm) **D4048-042 MOUNTING LUG ASSY (SHOWN)**

3			2	ĺ	
ITEM	QTY -041	QTY -042	P/N	Description	
	X		D4048-041	MOUNTING LUG ASSY	
		х	D4048-042	MOUNTING LUG ASSY	
1	1	1	D4048-1	MOUNTING LUG	
2	1		D4048-3	MOUNTING LUG	\neg
3		1	D4048-4	MOUNTING LUG	
4	4	4	D4048-9	BUSHING	
5	2	2	AN960JD416	WASHER	
6	2	2	AN4-14A	BOLT	
7	2	2	MS21042L4	NUT	

SHOP COPY

RETURNED

ENGINEL: 1916:

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

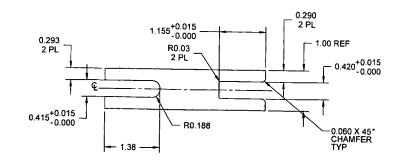
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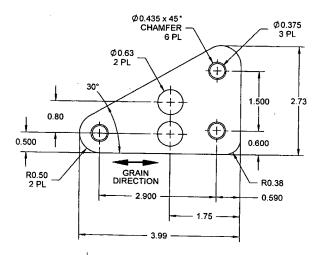
WORK ORDER

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REV.			DESCRIPTION B	Y DATE					
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DRAWN	ł	RF		HAWKESBURY, ONTARIO, CANADA					
CHECK	ED	9	DRAWING NO.	REV. A					
MFG. A	PPR.	91	□D4048	SHEET 1 OF 9					
APPROVED APPR.			TITLE	SCALE					
			MOUNTING LUG ASSY	NTS					
DATE	10.0	1 29	COPYRIGHT © 2010 BY DART AEROS THE DOCUMENT IS PRIVATE AND CONFORMAL AND IS SUPPLED ON THE	PACE LTD EXPRESS CONDITION THAT IT IS					

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W/O:		WORK ORDER CHANGES						***************************************		
DATE	STEP	PROCEDURE CHANGE By					Date G	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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D4048-1 MOUNTING LUG

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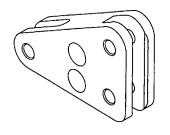
NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160) REF DART SPEC. M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE" (4.35.1) PER DART QSI 005 4.3 MASK Ø0.315 HOLES PRIOR TO POWDER COAT "3) TOLERANCES. PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: 0.47 lbs

7) WEIGHT: 0.47 lbs

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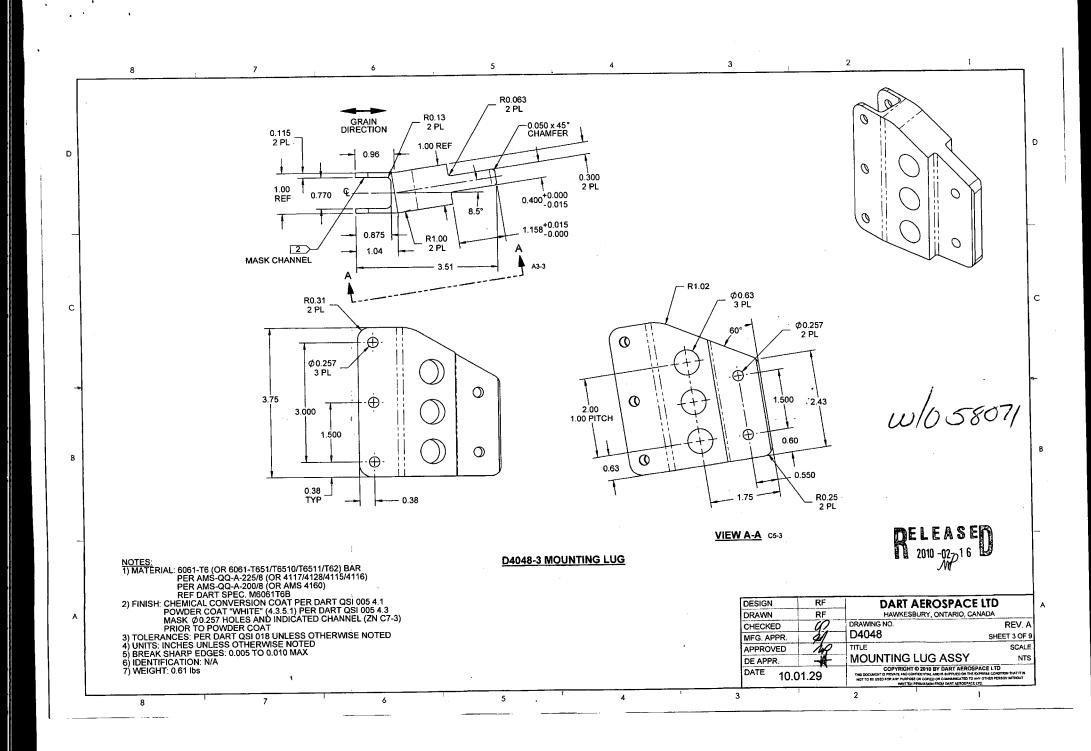
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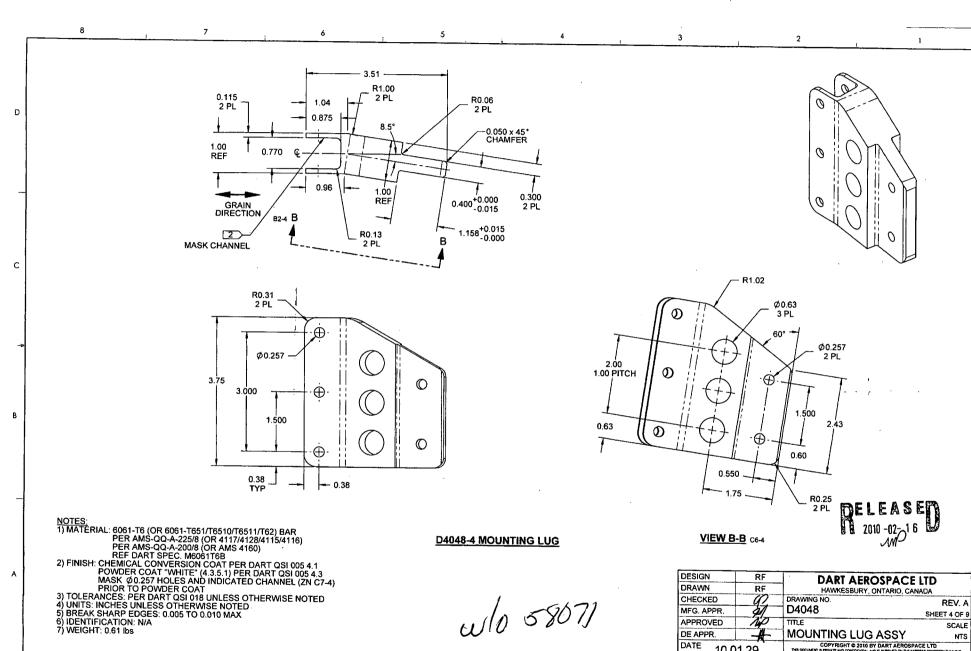
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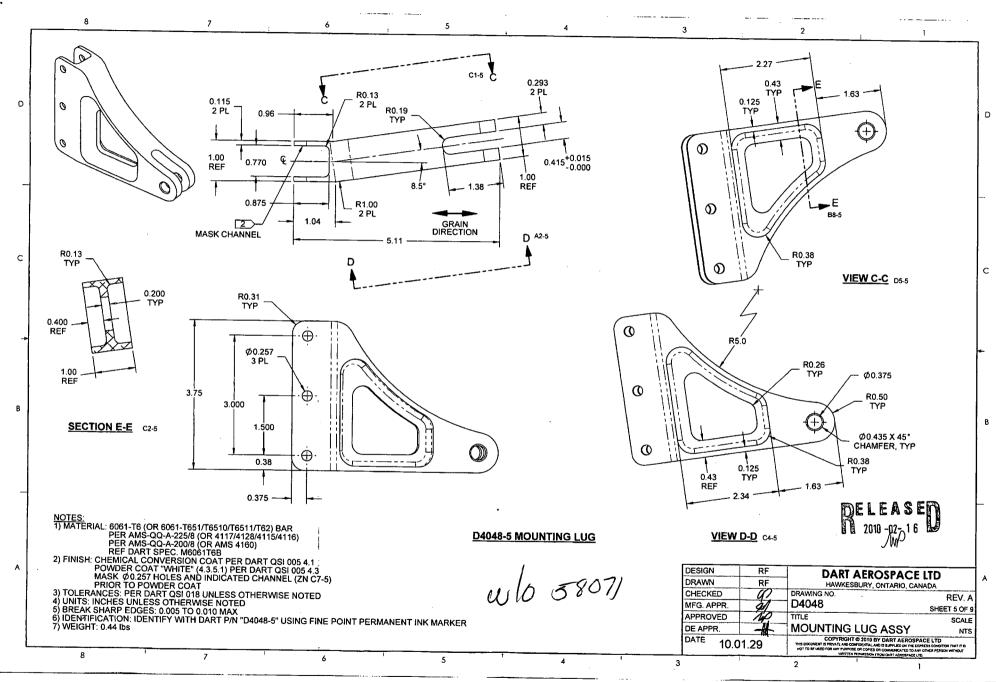
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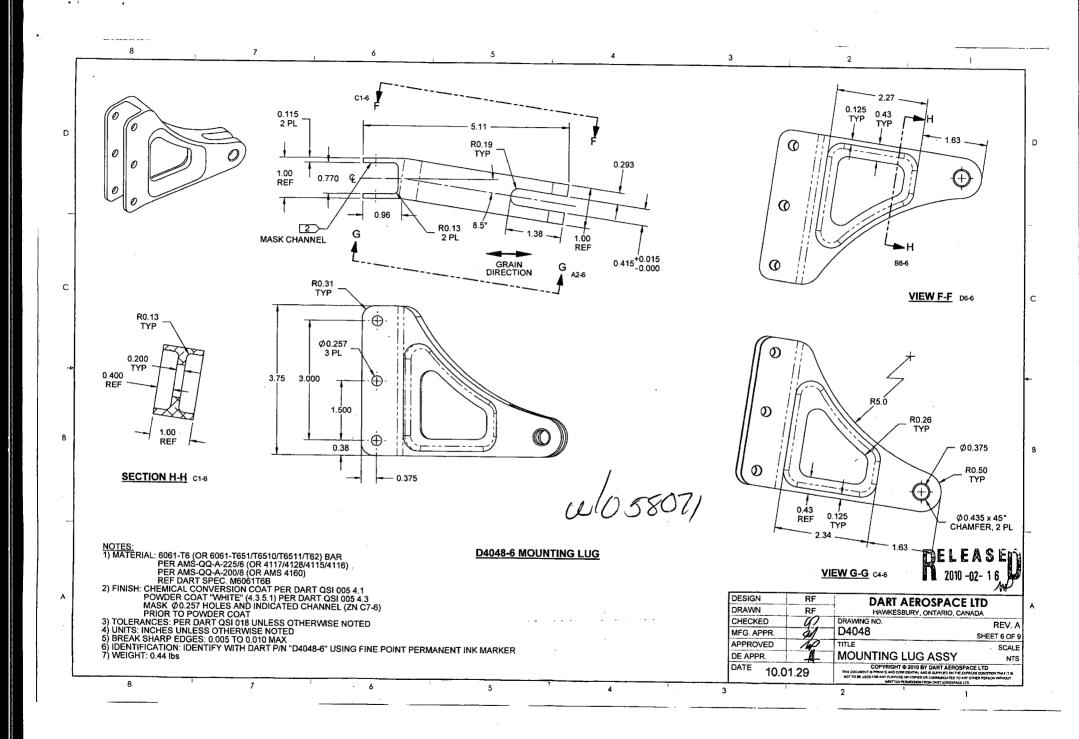
Approval QC Inspector
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Approval
QC Inspector



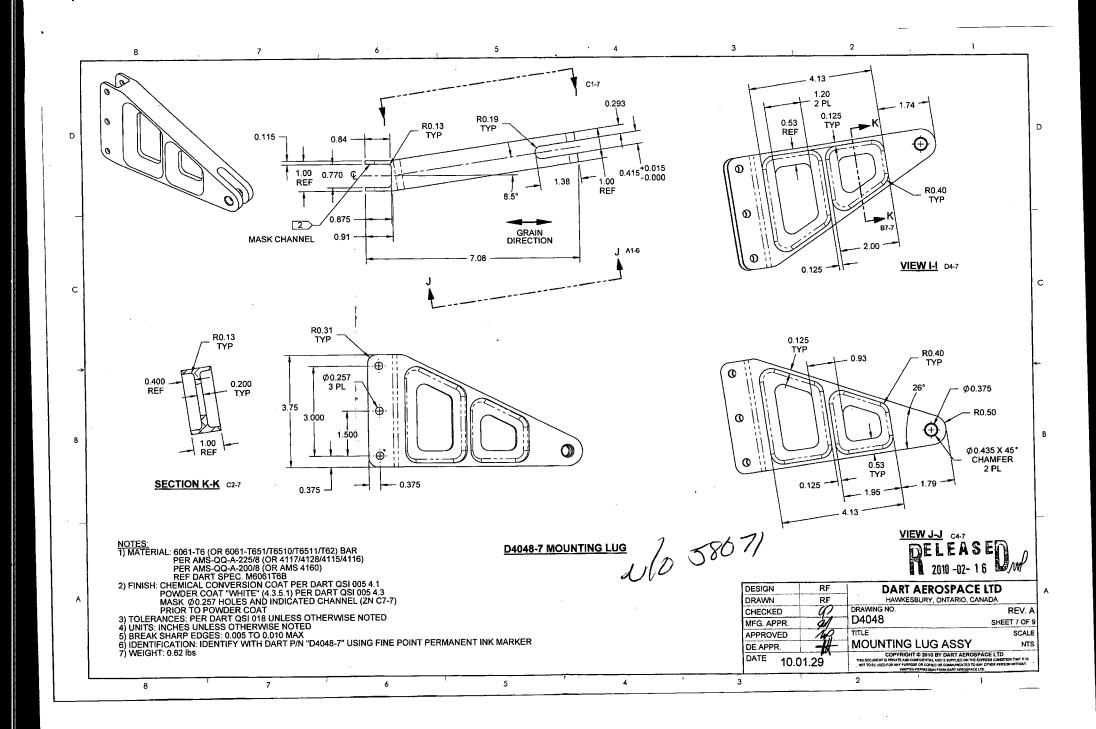
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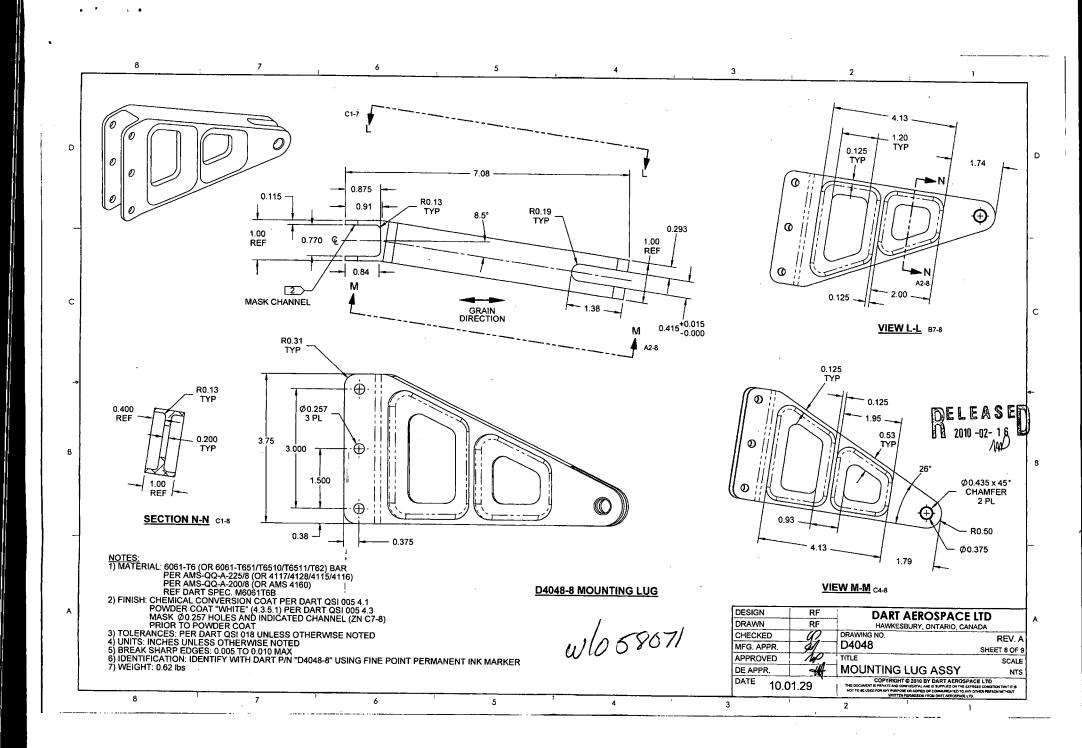
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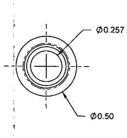
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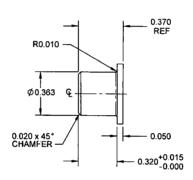


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D4048-9 BUSHING

W058071



NOTES:	
1) MATERIAL: AISI 303 STAINLESS STEEL BAR	
REF DART SPEC, M303B	
2) FINISH: NONE	1
	.:
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE	NOTEL
4) UNITS: INCHES UNLESS OTHERWISE NOTED	β
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX	5
6) IDENTIFICATION: N/A	
7) WEIGHT: 0.01libs	
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DESIGN	RF	DART AEROSPACE LTD				
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA				
CHECKED	a)	DRAWING NO. REV. A				
MFG. APPR.	94	D4048 SHEET 9 OF 9				
APPROVED	MP,	TITLE SCALE				
DE APPR.	-44-	MOUNTING LUG ASSY NTS				
DATE 10.0	1.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOSAMENT IS PRIVATE AND COMPRIBENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMENCENTED TO ANY POTRESPERSON WITHOUT WESTERN PERMANSION FROM DART AEROSPACE LTD.				

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W/O:			W	ORK ORDER CHANG	ES					
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